

IN THE CLAIMS:

Please replace claims 1 and 2 with the corresponding amended claims:

Sub C1

1. (Amended) A method of dry milling a material comprising:
providing a silicon nitride based cutting tool insert;
cutting at a cutting speed of 1000-3000 m/min; and
feeding to a cutting depth of 0.2-2 mm,
wherein the material comprises aluminum and cast iron.

a2

2. (Amended) The method of claim 1, wherein the cutting tool insert produces
a chip thickness of 0.09-0.17 mm.

Please add new claims 3 and 4 as follows.

Sub C1

3. (New) A method of dry milling a composite material, the method
comprising:
providing a silicon nitride based cutting tool insert;
cutting at a speed of 1100-2500 m/min; and
feeding to a cutting depth of 0.2-2 mm.

a3

3608.924 ft/mⁱⁿ
8202.1 ft/min

4. (New) The method of claim 3, wherein the cutting depth is 0.3-1.0 mm.
0.0118" - 0.0394"